

Work Order ID: 54831

December 22, 2009 2:16:53 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/12/22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr *

Revision Nbr

D2445/D350-588

Rev D/D

100



0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

8/10/24

CL CL 10/03/24

110



0.00

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11005 Description: D2445 Baggage Door Supplier: Delastek Ship to Delastek (1) D0588-041 label Certification of Conformity and process sheet from Delastek is required.

CL 09/12/22 ①

120



0.00

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

CL 10/01/24

Work Order ID 54831

December 22, 2009 2:16:53 PM



Page 2

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

S 10/03/01

Memo

0.00

Inspect as per Dwg D2445. ☐ Audit process sheet.

④

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble all of the above parts as per Dwg D350-588

85 10-03-16

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 06/07/17

Memo

0.00

④

P/10 →

Dart Aerospace Ltd

W/O: 54831

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/24	# 150.1	Perm. change ADD sken to Pick Kit 10-3-24				U	S 10/3/24
		Fix Parting numbers for kit (will ADD some for start)		10.03.24		U	S 10/3/24

Part No: D350-588-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/3/24	#100.1	Perm. change missing part from w/o ADD D2690-17 B* 56576 Qty +1 per kit 56567	sl	10.3.24			S 10/03/24	
		ADD to w/o + Bom. ADD copy of new Bom for Ref.	sl	10.03.24			S 10/03/24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

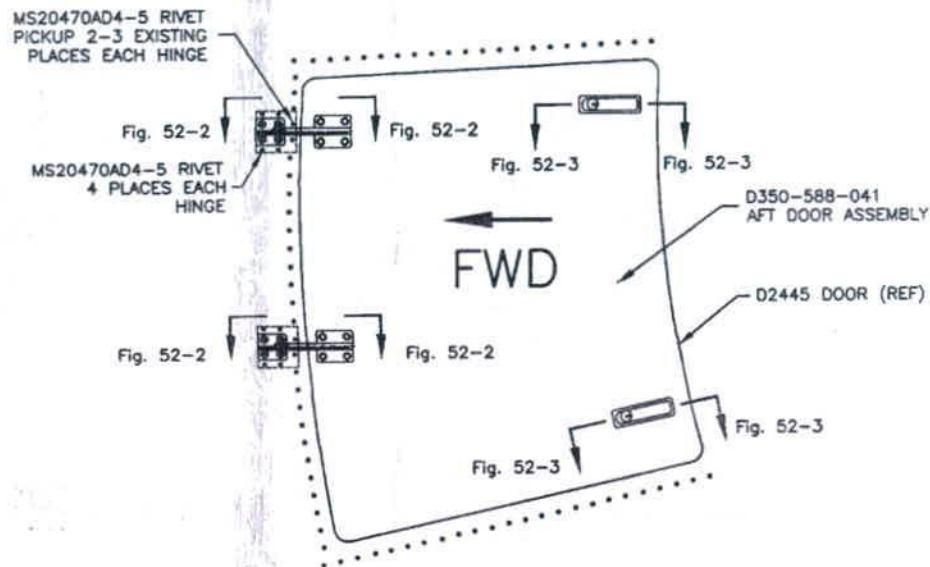


Figure 52-1: Baggage Door Outside View

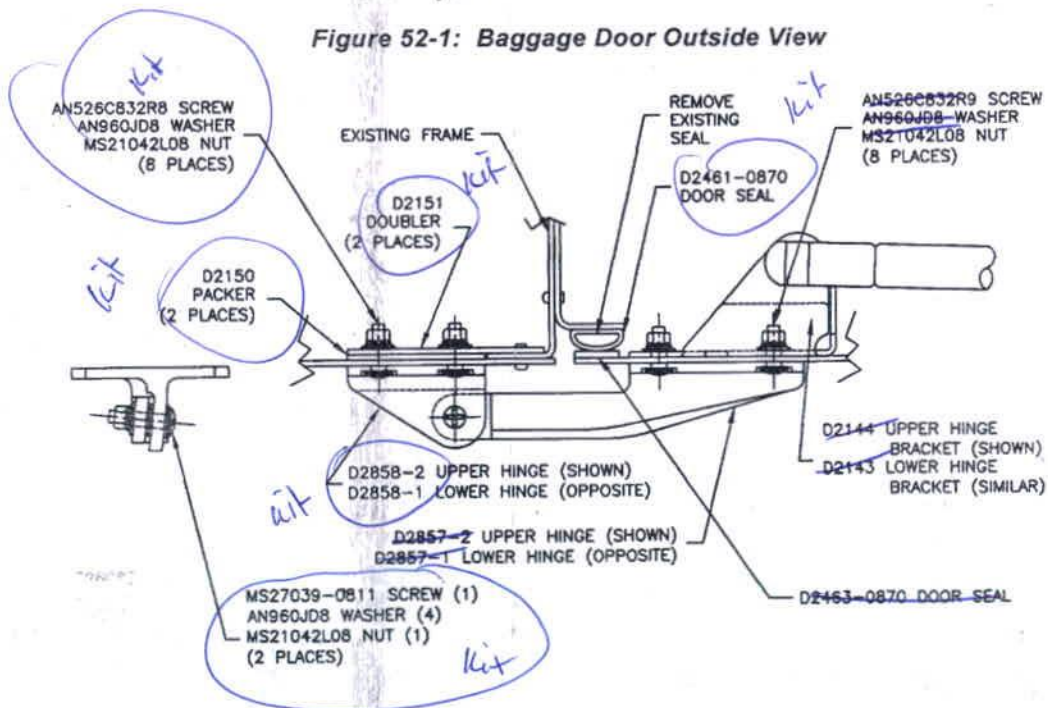


Figure 52-2: Hinge Detail

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Work Order ID 54831

December 22, 2009 2:16:53 PM



Page 3

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

* 160



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/09

70

8/10/09

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Rev D

10-3-24 SF

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/03/24

MF

10-3-24

Memo

0.00

Picklist Print

December 22, 2009 2:16:52 PM

Page 1

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No				Each	136.0000	2.0000			
Screw												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	136	
104394	3	
113064	100	
113096	33	

AN526C632R8		Purchased	No				Each	312.0000	8.0000			
Screw												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	312	
2405	312	

ST 10.07-16

+2

ST 10.03-16

+8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:52 PM

Page 2

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9		Purchased	No				Each	229.0000	8.0000			



Screw



21 10-03-26

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

229

B113840 x8

M113845
54 10-3-24

107376

51

108377

5

108928

14

110372

8

110915

1

111916

1

112492

149

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 2

Picklist Print

December 22, 2009 2:16:52 PM

Page 3

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,486.000	2.0000			



Washer

N451149003635

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

1486

M113288 +2

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

174

112369

22

113149

1000

85 10-03-16

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 3

Picklist Print

December 22, 2009 2:16:52 PM

Page 4

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,486.000	2.0000			



Washer

NAJ 1149 DO 3635



RT 10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1486

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

174

112369

22

113149

1000

M 113288

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 4

Picklist Print

December 22, 2009 2:16:52 PM

Page 5

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD8		Purchased	No				Each	1,217.000	16.0000			
----------	--	-----------	----	--	--	--	------	-----------	---------	--	--	--

Washer

ST 10-03-16

NAS1149DN8325
QSI D17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1217	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	
112314	366	
112385	720	

AN960JD8		Purchased	No				Each	1,217.000	8.0000			
----------	--	-----------	----	--	--	--	------	-----------	--------	--	--	--

Washer

ST 10-03-16

NAS1149DN8325
QSI D17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1217	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	
112314	366	
112385	720	

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 5

Picklist Print

December 22, 2009 2:16:52 PM

Page 6

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2143



Hinge Bracket

Manufactured

No

Each

29.0000

1.0000



BT 10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

37739

29

D2144



Hinge Bracket

Manufactured

No

Each

14.0000

1.0000



BT 10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

41174

14

D2150



Packer Doubler, Hinge

Manufactured

No

Each

16.0000

2.0000



B55016 10-3-24 94

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

45813

16

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 6

Picklist Print

December 22, 2009 2:16:52 PM

Page 7

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2151



Packer Doubler, Hinge

Manufactured

No

Each

60.0000

2.0000



10-3-24 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

51407

60

Each

34.0000

1.0000



10-3-24 SL

D2153



Door Prop

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

48373

34

Each

29.0000

1.0000



10-3-24 SL

D2154



Stud Bracket

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

44890

19

45814

10

1

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 7

Picklist Print

December 22, 2009 2:16:52 PM

Page 8

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly


Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237  Striker Plate		Manufactured	No				Each	64.0000	2.0000			



B55006 10-3-24 SF

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	9	
46162	9	
Main Warehouse		
ST022	55	
52327	55	

D2461



Neoprene "D" Seal

Manufactured No

170.7040 7.2500



10-3-24 SL
B55034

cut 1x
827" 2 neoprene
8/10/24 N

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	170.7039842	
34304	14.234	
39782	156.469984	

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 8

Picklist Print

December 22, 2009 2:16:52 PM

Page 9

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2463		Manufactured	No				f	577.1626	7.2500			
-------	--	--------------	----	--	--	--	---	----------	--------	--	--	--



Seal



RT 10-03-16

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

75.3752

B50075

31350

1.8278

34305

18.25

41121

3.75

43841

51.5474

Main Warehouse

ST404

501.7873684

50075

501.787368

Each

90.0000

2.0000

D2585



Mounting Channel



RT 10-03-16

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

64

45888

4

53798

60

Main Warehouse

ST37

26

51526

26

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 9

Picklist Print

Page 10

December 22, 2009 2:16:52 PM

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2586



Door Latch

Manufactured

No

Each

89.0000

2.0000



10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

* 89

45554

1

47183

2

50213

86

D2589



Keys, Key Chain, 350 Hinge

Manufactured

No

Each

56.0000

1.0000



10-3-2488

Warehouse

Loc Qty

Loc Code

Location

HONG KONG

ST

1

46840

15

46846

1

50378

40

D2621



Latch Plate, 350 Spacepod

Manufactured

No

Each

66.0000

2.0000



10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

66

46842

66

x2

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 10

Picklist Print

December 22, 2009 2:16:52 PM

Page 11

Work Order ID: 54831



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly


Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1  Hinge Bracket		Manufactured	No				Each	29.0000	1.0000			



ST 10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

41166

7

45788

4

50235

6

53464

12

B53019 x1

D2857-2



Hinge Bracket

Manufactured No

Each

25.0000

1.0000



ST 10-03-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

45797

13

53465

12

B55020

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 11

Picklist Print

December 22, 2009 2:16:52 PM

Page 12

Work Order ID: 54831



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2858-1



Hinge Bracket

Manufactured

No

Each

27.0000

1.0000



10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

43364

3

45798

24

D2858-2



Hinge Bracket

Manufactured

No

Each

19.0000

1.0000



B55063 10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

41439

4

45799

15

MS20426AD3-4



RIVET

Purchased

No

Each

7,765.000

12.0000



10-3-24 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7765

104374

3765

110398

4000

12

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 12

Picklist Print

December 22, 2009 2:16:52 PM

Page 13

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly


Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD4-5  Rivet, Universal Head		Purchased	No				Each	2,485.000	18.0000			

10-3-24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2485	
109031	6	
111916	2479	

MS210421.08



Nut

Purchased

No

Each

453.0000

10.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	453	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	31	
113149	100	
113226	200	

~~113749~~

113749 10-3-24 SP

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 13

Picklist Print

December 22, 2009 2:16:52 PM

Page 14

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS210421.08

Purchased

No

Each

453.0000

8.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

453

110002

24

111889

30

112243

43

112492

24

112612

1

112794

31

113149

100

113226

200

M 113749

IT 10-03-16

MS210421.3

Purchased

No

Each

2,372.000

4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2372

110844

35

111274

27

111668

64

112314

1746

112385

500

M113537 10-3-2009

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 14

Picklist Print

December 22, 2009 2:16:52 PM

Page 15

Work Order ID: 54831

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly


Comments:

Start Date: 12/22/09

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No				Each	2,372.000	2.0000			

10-03-16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

MS27039-08-11

Purchased

No



Screw

Each

76.0000 2.0000



10-3-24 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
111977	76	

2

December 22, 2009 2:16:52 PM

Shop Packet Print

Page 15

Picklist Print

December 22, 2009 2:16:52 PM

Page 16

Work Order ID: 54831



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/22/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15 Screw		Purchased	No				Each	163.0000	2.0000			
<div style="text-align: right;"> 10-03-16 </div>												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	103
106903	3
108169	4
109321	4
111916	52
<u>112794</u>	100

D24457

Purchased.

CL10/3/23

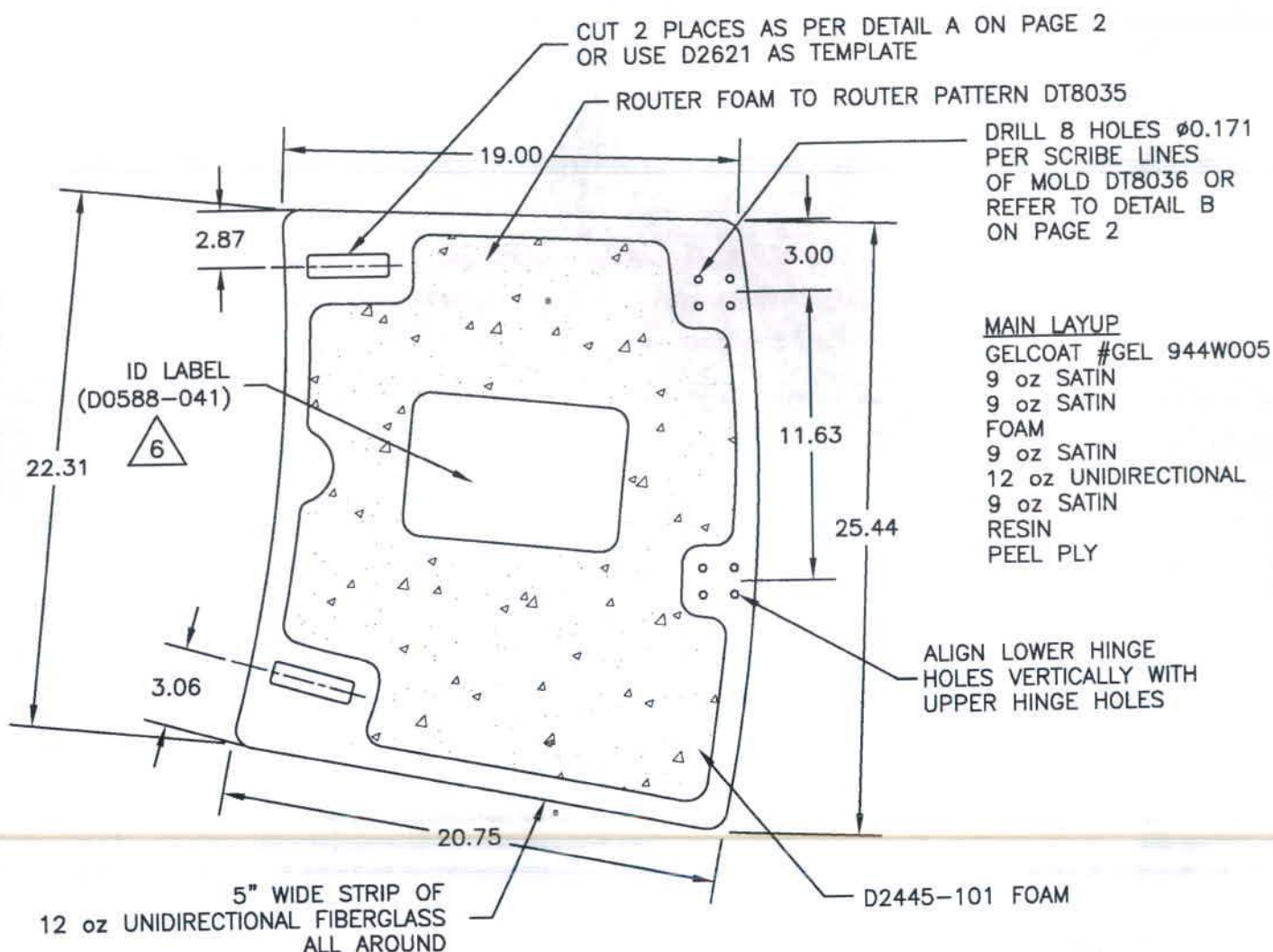
December 22, 2009 2:16:52 PM

Shop Packet Print

Page 16

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D. SHEET 1 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

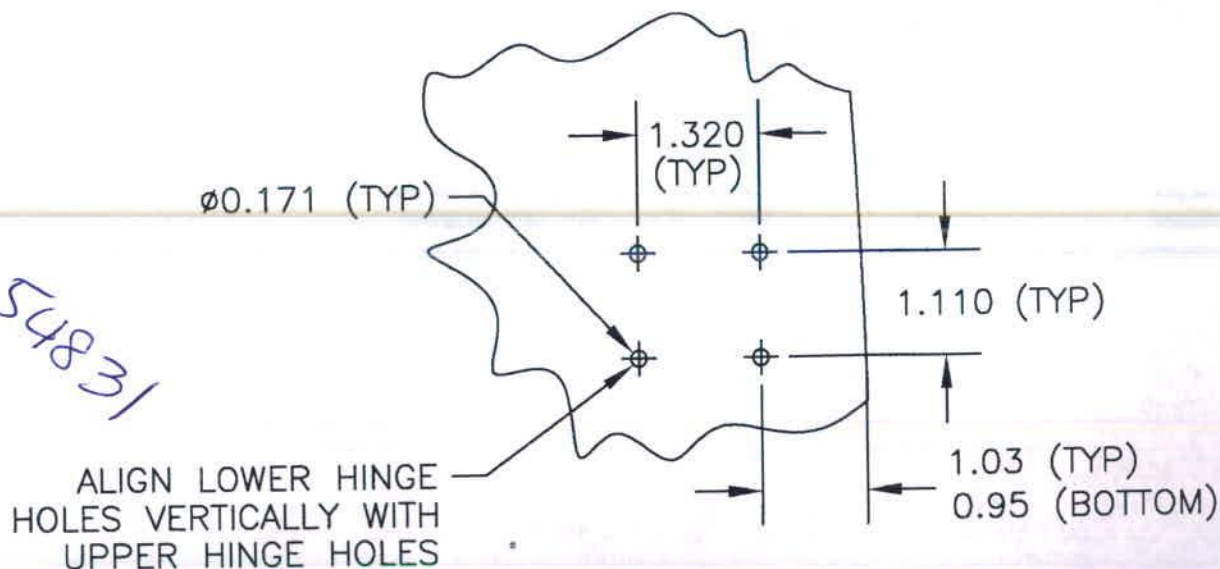
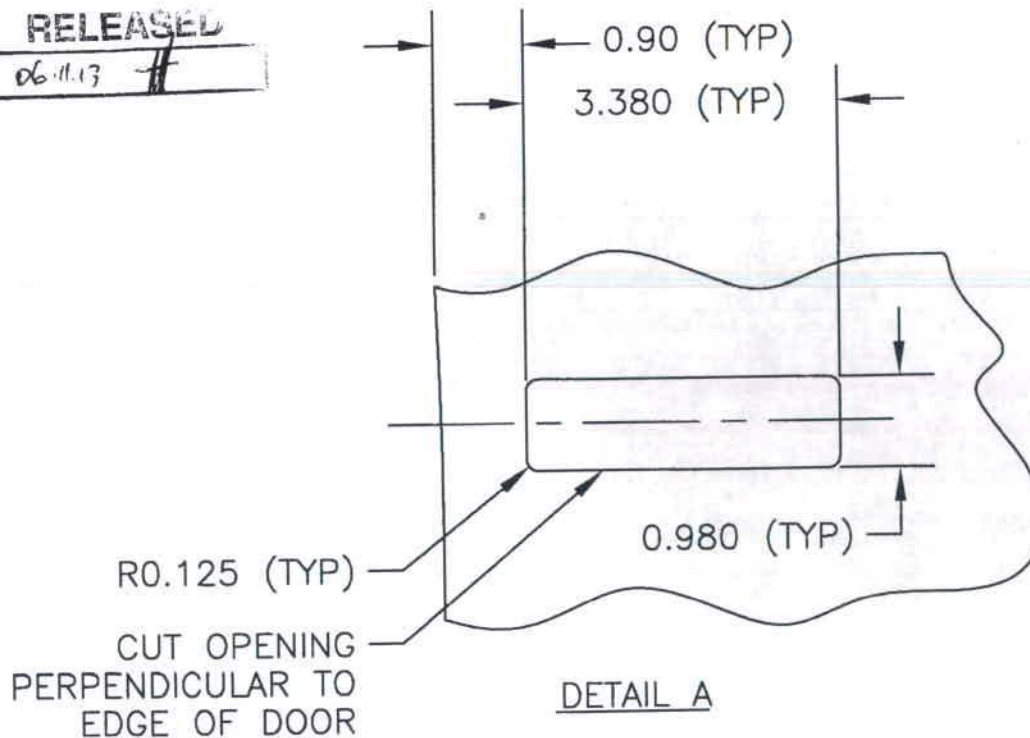
Cx 09/12/22
WID: 54831

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED

06.11.13



Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13298
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson		
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233		
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #		
27/01/2010	06/01/2010	6081	Chantal Lavoie		PO11005			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description				
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54830 Drawing N° : D2445 Rév.: D Job: 43642				U de M : Each
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54831 Drawing N° : D2445 Rév.: D Job: 43643				U de M : Each
S 10/03/01								

S
10/03/01

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357



☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

8. Lundi, 2009-02-09 08:10:42
sateur: Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
Numéro Job : 43643
Numéro Soumission : 2017
Numéro B.A. :
Date fois : 2009-02-09 No. B.V. :
Dernière Rev. : NC
Rem. fois :
Job précédente : 43642

Nom Dessin : AFT BAGGAGE DOOR D2445
Numéro Article : DKC134-0013
Numéro Dessin : D2445
Projet Numéro : DKC134
Révision dessin : D
Matériel : Fibre 7781 et Résine 411-350
Date Dûe : 2009-02-16

Qté: 1 Udm: UNITE



Crit par :
Vérifié & Approuvé par :
Commentaires :
N° de pièce Dart Aerospace: D2445
N° Delastek Composites: DKC134-0013
N° de projet Delastek: DK-362

Process Sheet Rév.: 10 Modification du planning afin d'y inclure le
N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC

Commentaire Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentaire Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s)
Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-26097-1

4.0	AAC0275	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

Form: rprocess

lisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
 Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
 Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
5.0	AC0260	Acetone
Commentair Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s) Acetone		
6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs PRÉPARATION DU MATÉRIEL Faire la préparation du matériel : Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone. Date: <u>8/10/10</u> Sceau: Temps Début: _____ Temps Fin: _____		
7.0	GEL COAT.	APPLICATION DE GEL COAT
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs APPLICATION DE GEL COAT À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70. Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement. Autocontrôle de fabrication. (Visuel du Gel Coat) Date: <u>8/10/10</u> Sceau: Temps Début: _____ Temps Fin: _____		
8.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s) Tissu à délaminer Release ply B		
9.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s) Wrightlon 5200 Bleu P3		
10.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s) Feutre de drainage N° Airweave N 10		

Form: rprocess

Client: DART Dart Aerospace Ltd.



Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43643

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
11.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s) Stretchlon 200 poche à vide Vert		
12.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y		
N° de Lot: 1-26083-1		
13.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s) Fiberglass 12 oz Unidirectional		
N° de Lot: 1-22549-1		
14.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.
1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 18 JAN 88 Heure Début: _____ Heure Fin: _____ Sceau: 

16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

Client: DART Dart Aerospace Ltd.
 Numéro Job: 43643

 Nom Dessin: AFT BAGGAGE DOOR D2445
 Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

 Commentaire Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRAMME(s)
 Résine (411B7530) 411-350 promo. 75min.

 N° de Lot: 1-26248-1

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------


 Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

 Date: 18 Jan 10 Heure Début: 10:50 Heure Fin: 10:55 Sceau:


19.0	LAMINAGE	LAMINAGE PIÈCE DART
------	----------	---------------------


 Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
 LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

 Date: 18 Jan 10 Heure Début: 10:55 Heure Fin: 11:05 Sceau:


20.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------


 Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
 FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

 Date: 18 Jan 10 Heure Début: — Heure Fin: — Sceau:

 Curing début: 10:55 Curing Fin: 8:00

Client: DART Dart Aerospace Ltd.
 Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
 Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0042 PINTE(s)/Unit Total: 0.0042 PINTE(s)
 Catalyst N° DDM-9

N° de Lot: 1-22176-1

22.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)
 Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-25959-1

23.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
 PRÉPARATION DU MATÉRIEL DART

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 16/09/99 Heure Début: _____ Heure Fin: _____ Sceau: _____



24.0 AAC0452 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)
 Polybond B46F

N° de Lot: 1-25391-1

25.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
 Foam Core N° D2445-101 (Pour AFT Baggage Door)

43653

26.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
 ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 19 Jan 00 Heure Début: 9:05 Heure Fin: 9:15 Sceau: _____



Client: DART Dart Aerospace Ltd.
Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE


Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 19/01/10 Heure Début: 9:15 Heure Fin: 9:25 Sceau:



Curing Début: 9:05 Curing Fin: 10:35

28.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

29.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26248-1

30.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART


Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 19/01/10 Heure Début: 3:15 Heure Fin: 3:25 Sceau:



31.0

LAMINAGE.

LAMINAGE PIÈCE DART


Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Form: rprocess

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 19/01/10 Heure Début: 3:25 Heure Fin: 3:55 Sceau:



32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 19/01/10 Heure Début: 3:55 Heure Fin: 4:25 Sceau:



Curing Début: 3:25 Curing Fin: 8:00

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abîmer les coins et les "edges".

Date: 20-1-10 Heure Début: 13h00 Heure Fin: 13h15 Sceau:



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un "Bushing" 1/16" de mur.

Percer les "Latch" et les trous de penture selon le dessin N° D2445.

Date: 20-1-10 Heure Début: 13h15 Heure Fin: 14h30 Sceau:



Form: rprocess

isateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
35.0	AAC0062	Label N° D0588-041
Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Label N° D0588-041 # Lot: 1-26247-1		
36.0	AAC0444	Surface Veil
Commentaire Qty.: 0.07 VERGE CAR(s)/Unit Total : 0.07 VERGE CAR(s) Surface Veil		
37.0	AAC0501	Résine Mia-Poxy
Commentaire Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s) Résine Mia-Poxy # Lot: 1-25679-1		
38.0	AAC0502	Durcisseur 95 Pour Résine Mia-Poxy
Commentaire Qty.: 0.007 PINTE(s)/Unit Total : 0.007 PINTE(s) Durcisseur 95 Pour Résine Mia-Poxy # Lot: 1-25679-2		
39.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser scher pendant 4 heures.

Date: 25/6/10 Heure Début: 9:30 Heure Fin: 9:45 Sceau:

40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-7191-1

41.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 25-1-10 Heure Début: 8h30 Heure Fin: 9:15 Sceau:

Form: rprocess



Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43643

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description:

43.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-25612-2

44.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S


Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S 2-24803-3


45.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 27/01/10 Sceau: 

Quantité: 1 Date: 26/01/10 Sceau: 

Quantité: _____ Date: _____ Sceau: _____


Quantité: _____ Date: _____ Sceau: _____

46.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.

Date: 27-01-10 Heure Début: 10:15 Heure Fin: 10:30 Sceau: 


47.0 EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 27/1/10 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries